

42

DART AEROSPACE LTD.	Work Order :	21453
Description: 206 Saddle, Outboard, Right Side	Part Number:	D2665-2
Drawing: D2665 Rev B	Qty:	8

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order <i>Doc. not required RF 02/09/16</i>	<i>EP</i>	<i>04.09.03</i>	<i>8</i>
2	STORES	Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 7.88 Grain Along Long 7.88 Length (B6101-003) RF 02/09/16 Batch No: <i>B209822</i>	<i>EP</i>	<i>05/02/14</i>	<i>8</i>
3	HAAS	Program batch number. <i>B22241</i>	<i>EP</i>	<i>05/02/14</i>	<i>8</i>
4	QC	Inspect part number and batch number are programmed correctly.	<i>SA</i>	<i>05/02/14</i>	<i>8</i>
5	HAAS	Fixturing W/O No. <i>N/A</i> Fixturing Inspection last completed on <i>05/02/14</i> by <i>EP</i>	<i>EP</i>	<i>05/02/14</i>	<i>8</i>
8	HAAS	Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet	<i>ML</i>	<i>05/02/15</i>	<i>8</i>
9	HAAS	Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet	<i>ML</i>	<i>05/02/15</i>	<i>8</i>
10	HAAS	Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet	<i>ML</i>	<i>05/02/15</i>	<i>8</i>
11	LAGUN	Machine Keyway and inspect per attached dimension sheet	<i>ML</i>	<i>05/02/15</i>	<i>8</i>
12	METAL	Deburr	<i>ML</i>	<i>05/02/15</i>	<i>8</i>
13	HAAS	Inspect Level 1	<i>ML</i>	<i>05/02/15</i>	<i>8</i>
14	QC	Inspect Level 8	<i>EP</i>	<i>05/02/16</i>	<i>8</i>
15	METAL	Acid etch and Alodine as per QSI 005 4.1	<i>ML</i>	<i>05.02.23</i>	<i>8</i>
16	FINISHING	Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3	<i>ML</i>	<i>05.02.23</i>	<i>8</i>
17	QC	Inspect Level 3	<i>CL</i>	<i>05/02/23</i>	<i>8</i>
18	STORES	Pack in foam, identify and stock.	<i>CL</i>	<i>05/02/23</i>	<i>8</i>
19	EXPEDITING	Close Work Order Job Cost / Part <i>99.89 Sur 05/02/24</i> <i>(8)</i>	<i>EP</i>	<i>05.08.02</i>	<i>8</i>

Rev	Date	Change	Revised By	Approved
A	97.07.24			
B	98.09.02	Inspection Levels, Added Powder Coat	KS	
C	00.11.01	Removed P/O for Powder Coat – in house process	EC	

RELEASED

DEC 1 8 2000

Work Order:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector	

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncb.doc

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	21453
Description: 206 Saddle, Outboard, Right side	Part Number:	D2665-2
Inspection Dwg: D2665 Rev. B.		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.120	0.125	0.129	0.129		
B	0.100	0.140		0.123	0.124	0.128	0.128		
C	0.100	0.140		0.119	0.113	0.120	0.116		
D	0.210	0.230		0.212	0.221	0.222	0.219		
E	1.245	1.255		1.251	1.251	1.251	1.251		
F	1.245	1.255		1.251	1.251	1.251	1.251		
G	5.990	6.010		5.999	6.000	6.006	6.000		
H	0.510	0.515		0.511	0.512	0.512	0.511		
I	1.674	1.684		1.680	1.678	1.679	1.680		
J	2.495	2.505		2.498	2.499	2.499	2.501		
K	0.257	0.262	DT8683	✓	✓	✓	✓		
L	0.312	0.317	DT8686	✓	✓	✓	✓		
M	0.235	0.240		0.235	0.237	0.238	0.237		
N	0.100	0.140		0.112	0.121	0.121	0.120		
O	0.540	0.560		0.544	0.550	0.551	0.551		
P	0.490	0.510		0.500	0.497	0.504	0.500		
Q	3.609	3.619		3.615	3.613	3.612	3.612		
R	2.470	2.510		2.500	2.497	2.499	2.502		
S	0.240	0.270		0.249	0.250	0.254	0.255		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	0.313	0.318	DT8686	✓	✓	0.316	OK		05.02.14
V	1.125	1.145		1.137	1.142	1.135	1.135		
W	1.565	1.585		1.576	1.580	1.571	1.573		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>mf</i>	Audited by: <i>EP</i>
Date: 05/02/15	Date: 05/02/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF <i>RF</i>	<i>#</i>

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Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.127	0.127	0.128	0.127		
B	0.100	0.140		0.125	0.127	0.125	0.127		
C	0.100	0.140		0.112	0.118	0.115	0.115		
D	0.210	0.230		0.219	0.222	0.221	0.221		
E	1.245	1.255		1.251	1.257	1.257	1.251		
F	1.245	1.255		1.251	1.257	1.251	1.257		
G	5.990	6.010		6.001	6.000	6.000	6.000		
H	0.510	0.515		0.514	0.513	0.512	0.512		
I	1.674	1.684		1.681	1.680	1.678	1.679		
J	2.495	2.505		2.500	2.499	2.499	2.501		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		0.237	0.237	0.237	0.237		
N	0.100	0.140		0.121	0.121	0.120	0.121		
O	0.540	0.560		0.552	0.552	0.548	0.551		
P	0.490	0.510		0.496	0.497	0.502	0.502		
Q	3.609	3.619		3.617	3.611	3.613	3.612		
R	2.470	2.510		2.497	2.501	2.499	2.500		
S	0.240	0.270		0.254	0.256	0.257	0.254		
T	0.100	0.180		0.140	0.146	0.140	0.146		
U	0.313	0.318	DT8686						
V	1.125	1.145		1.132	1.133	1.133	1.134		
W	1.565	1.585		1.571	1.572	1.572	1.573		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JML
Date:	05/02/15

Audited by:	RF
Date:	05/02/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	

RELEASED
03.06.18

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 03, 2004
11:45 am

Work Order No : 0021453
Project Name : D2665-2
Project For : WK442
Work Order Type : Main
Main WO Number :
House Part Number : D2665-2

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Description : Saddle, RH, Fwd,Aft, Out
Manufactured : Yes
Amount Req'd : 8
Amount Done : 0
Start Date : 09-03-04
Est Finish Date : 10-14-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Order Entry No :
OE Value : 0.00

Est Margin : 0.000%
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00